


Date: Tuesday, 3/20/2007 2:28:58 PM  
 User: Eric Charbonneau

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACKING PLATE
Job Number	: 30679		
Estimate Number	: 10506		
P.O. Number	: N/A	Part Number	: D2228
This Issue	: 3/20/2007 S.O. No. : N/A	Drawing Number	: D2228 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 2/8/2007 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 24958	Material	: N/A
Written By	: 	Due Date	: 2/23/2007 Qty: 200 Um: Each
Checked & Approved By	: _____		
Comment	: Est:B 00.08.22 Re-format EC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S063 5052-H32 .063 Sheet



Comment: Qty.: 0.0227 sf(s)/Unit Total : 4.5400 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: ml 9059

ml 07 03 21

(200)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2228

Dwg Rev: B

Prog Rev: B

ml 07 04 02

ml 07 03 21

(200)

2-Deburr if necessary

ml 07/04/03

200

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 07 04 02

(200)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 07/04/02

200

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(200X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.l

07/04/04

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Job Number: 30679

Part Number: D2228

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FX

07/04/04

200x

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



200x

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H

07/04/04

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Pc 7/4/05 (200)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



200

Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



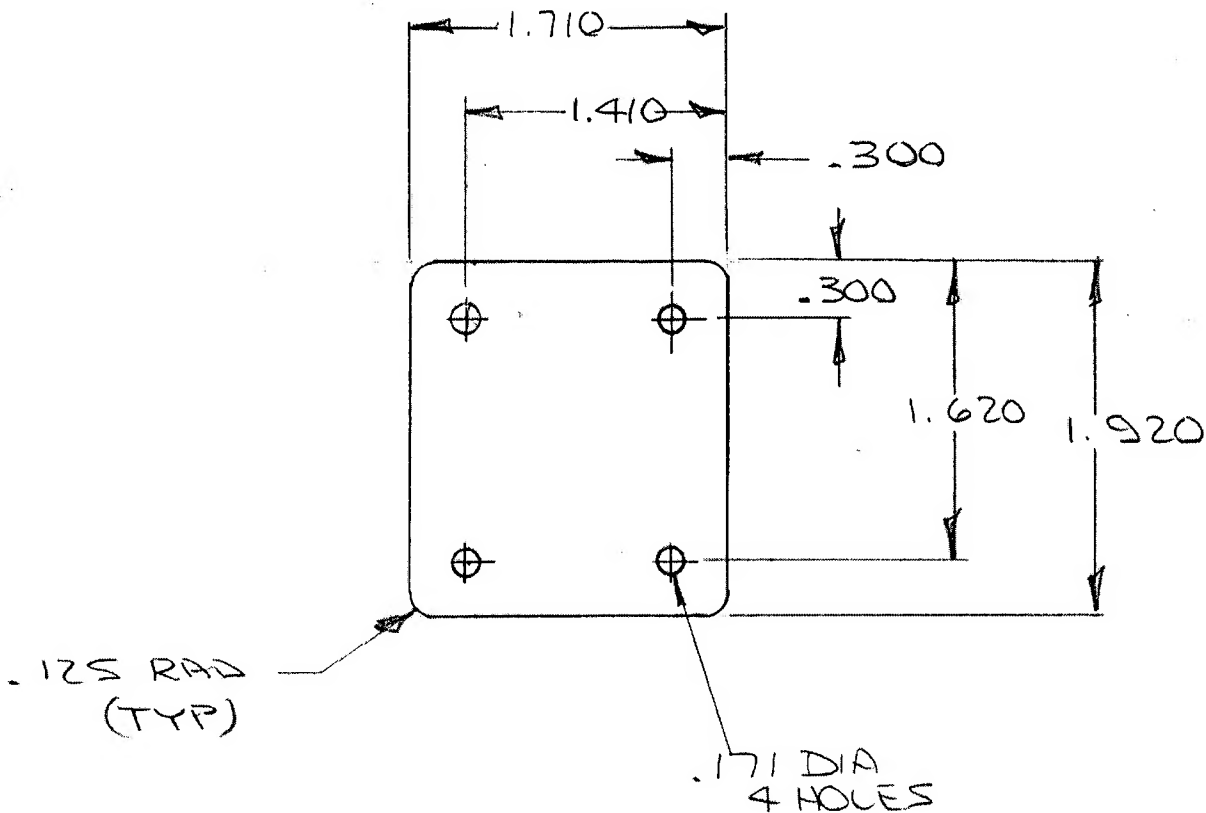
h 07-01-05

**DART**




DRAWN BRADLEY 94.3.23	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.23	DRAWING NO. D2228	REV. 8
STRESS	TITLE BACKING PLATE	
B	00.09.11	UPDATE FINISH SPEC. <del>A</del> UP

RELEASED  
00.04.12 #



MATERIAL : 5052-H 32 .063 THICK  
(QQ-A-250/8)

FINISH :  CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30679

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30679
<b>Description:</b> <del>Bear paw</del> BACKING Plate		<b>Part Number:</b> D2228
<b>Inspection Dwg:</b> D2228 <b>Rev:</b> B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 0.171	+0.005-0.001	0.173	✓		VERN	
B	1.920	+/- 0.010	1.918	✓		VERN	
C	1.710	+/- 0.010	1.709	✓		VERN	
D	1.410	+/- 0.010	1.409	✓		VERN	
E	1.620	+/- 0.010	1.620	✓		VERN	
F	0.300	+/- 0.010	0.298	✓		VERN	
G	0.300	+/- 0.010	0.304	✓		VERN	
H	R.125	+/- 0.010	R.125	✓		Radius Gauge	
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b> <i>MM</i>	<b>Audited by:</b> <i>MM</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/03/02	<b>Date:</b> 07/04/02	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	